

Work Order ID 70301

Thursday, June 02, 2011 1:52:49 PM

Page 1

Item ID: D3209-041

Accept

Revision ID:

Item Name: Bracket Assembly

Start Date: 6/8/2011 Start Qty: 5.00

Required Date: 6/24/2011 Req'd Qty: 5.00

Reference:

Handwritten signature

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3209	Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)

Handwritten signature and date 11/06/09

Handwritten 5

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3209-1 as per Folio FA345 and Dwg D3209-1

11

Deburr and Tumble

Handwritten signature and date 11/06/09

Handwritten 5

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Handwritten signature and date 11/06/09

Handwritten 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Customer:

Reference:

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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 11/06/09

5 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

5X 0 m-11/06/10

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

Note: Cover the hole for D3209-1 before powder coat. ☐ START TIME: 11:30 ☐ FINISH TIME: 12:00 OVEN TEMPERATURE: 320 OF

5X 0 m-11/06/13

NA 115128

12:00

320 OF

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:




Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						5 of 5 6/10/13	
161  Small Fab Small Fab	Small Fab press fit bushing as per dwg	0.00 0.00							
170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

JS 11/06/13 (S)

(A)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 6/8/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location	0.00							
Packaging									
Packaging	Memo	0.00							
190	QC21- Final Inspection - Work Order Release	0.00							
QC									
Quality Control	Memo	0.00							

11/6/14 SL (S)

11/6/14 (S)

mk
11-06-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

Thursday, June 02, 2011 1:52:46 PM

Page 1

Work Order ID: 70301

Parent Item: D3209-041

Parent Item Name: Bracket Assembly



Start Date: 6/8/2011

Required Date: 6/24/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP A1104.06.09 New issue TKJ/RF11

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3209-3		Manufactured	No			100	Each	39.0000	1	5			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Bushing

Location

Loc Qty

Loc Code

ST041

39

40930

39

M6061T6B1.500X01.25
0

Purchased

No

170

f

11.3278

0.175

0.921053



6061-T6 Bar 1.50 x 1.25

Location

Loc Qty

Loc Code

MAT004

11.3278

→ 107461

0.9

110936

10.4278

Handwritten signature and date: 6/5/11/06/13

Handwritten signature and date: 6/9/11/06/09

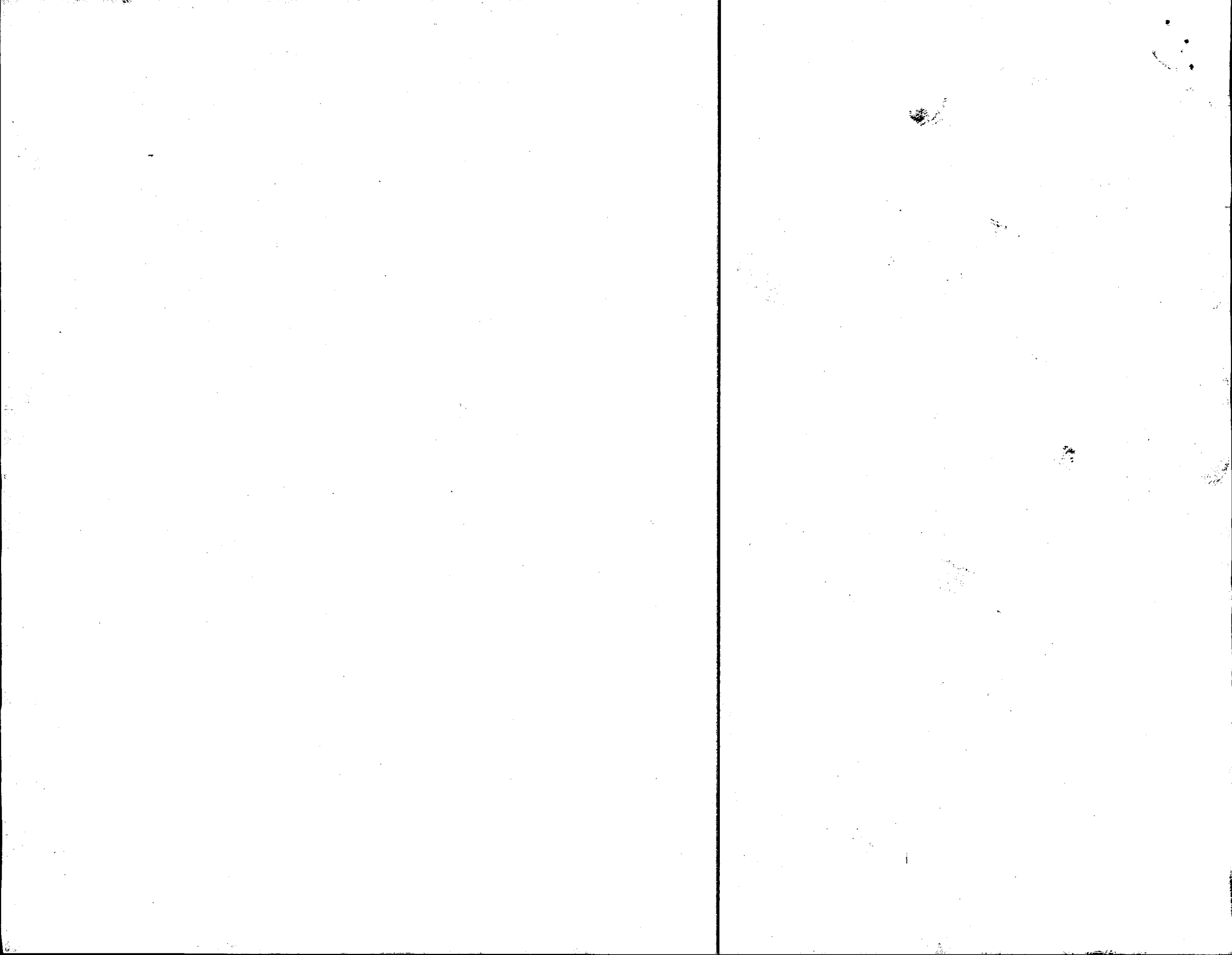
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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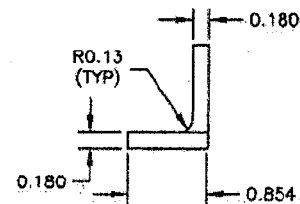
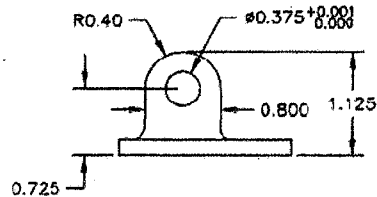
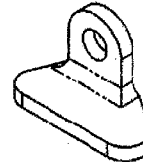
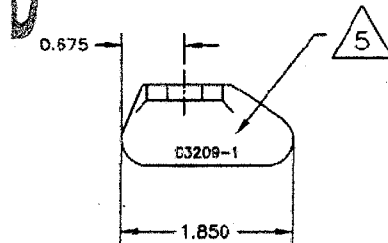




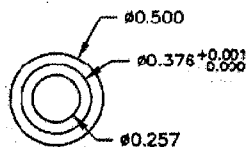
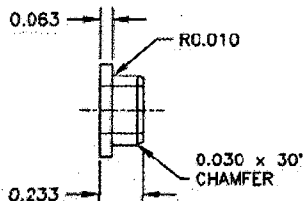
DESIGN FF	DRAWN BY FF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05

w/070301



D3209-1 BRACKET

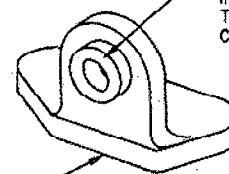


**D3209-3 BUSHING
SCALE 1:2**



D3209-041 ASSEMBLY

D3209-3 BUSHING
PRESS FIT, HEAD
AT THIS FACE
INSTALL AFTER
THE CONVERSION
COAT



D3209-1 BRACKET; D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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